



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

649.4812

Job Sheet 165746



Part No: 649.4812

Job Qty: 6 ea

Part Name: Shim



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/6/17

Job Tracking No:

Due Date: 10/20/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP REV:A 12.11.01 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	6 Ea	10/20/17	0.00	0.00	Start up container	
110	Waterjet	6 pcs	10/20/17	0.00	0.31	Waterjet1	
120	QC	6 pcs	10/20/17	0.00	0.00	QC2	
130	QC	6 pcs	10/20/17	0.00	0.00	QC8	
160	Outsource	6 pcs	10/20/17	0.00	0.00	Outsource4	
170	Packaging	6 pcs	10/20/17	0.00	0.00	Packaging2	
180	QC	6 pcs	10/20/17	0.00	0.00	QC5	
210	Packaging	6 pcs	10/20/17	0.00	0.00	Packaging3	
220	QC21-SA	6 Ea	10/20/17	0.00	0.00	QC21	

Part Op 110 - 1-Cut as per Dwg Dwg Rev: _____ Prog Rev: _____ 2-Deburr if necessary
Descriptions: 160 - ISSUE P/O: _____ HARD ANODIZE, COLOR BLACK AS PER DWG. (SEE NOTE 2) PRIME IAW MIL-P-23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 2)
210 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

2.7 mils thickness primer

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M2024T3S.050	2	125	0	0

Part Specifications

Specifications could not be found.

Plex 10/6/17 10:16 AM Dart.lajeunesse.marie

649.4812
Status: Stock

Part: 646.4812 B165746

Created: 9/30/17 10:36 AM DART.MICHAUD-FEBRILLE.VICTORIA



Serial No: S000003

Printed By: Goldston, Justin 10/2/17 10:44 AM

DART
AEROSPACE
S004457

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Shim

PART NO: 649.4812
Revision:
Operation: Outsource
Quantity: 6
Change No:

Mfg Date: 10/31/17
Job No: 165746

Status: Stock

Part: **649.4812 B165746**

Created: 10/11/17 7:36 AM DART.LACELLE.LINDA



Serial No: **S000279**

Printed By: Lacelle, Linda 10/11/17 7:35 AM

Work Order ID 165746

Monday, August 28, 2017 12:58:26 PM

165746

Page 1

Item ID: 649.4812

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Shim

Start Date: 9/12/2017 Start Qty: 6.00

6

Cust Item ID:

Required Date: 10/3/2017 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: DAS Date: AUG 31 2017

Tooling:

Date:

Run Start ***NR1***QC: 21
9-89

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

649.4800

B C I 17.09.13

0.00

110

110

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: 4Prog Rev: 4

2-Deburr if necessary

0.27

617/09/22DAS
40
9-89

120

120

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

617/09/22DAS
40
9-89

Work Order ID 165746

Monday, August 28, 2017 12:58:26 PM

165746

Page 2

Item ID: 649.4812

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Shim

Start Date: 9/12/2017 Start Qty: 6.00

6

Cust Item ID:

Required Date: 10/3/2017 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130						<u>6</u>	<u>Ø</u>	SEP 22 2017	DAS 9 9-89
QC	Memo	0.00							
Quality Control									
160	Outsource process-Anodize per QSI017 4.1.10.1	0.00							
160						<u>6</u>		SEP 27 2017	DAS 13 9-89
Outsource4	Memo	0.00							
Outsource process - Anodize	ISSUE P/O: <u>37898</u>								
	HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)								
	PRIME IAW MIL-P-23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 2)								
170	Receive & Inspect for Damage & Mat'l Certs	0.00							
170									
Packaging	Memo	0.00							
Packaging									

6x807-10-30

Work Order ID 165746

Monday, August 28, 2017 12:58:26 PM

165746

Page 3

Item ID: 649.4812**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Stop*****NS2*****Item Name:** Shim**Start Date:** 9/12/2017 **Start Qty:** 6.00***6*****Cust Item ID:****Required Date:** 10/3/2017 **Req'd Qty:** 6.00***6*****Customer:****Reference:****Approvals:****Process Plan:** _____**Date:** _____**Tooling:** _____**Date:** _____**Run Start*****NR1*****QC:** _____**Date:** _____**SPC (Y/N):** _____**Date:** _____**Stop*****NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

210

Identify as per dwg & Stock Location: _____

0.00

210

Packaging

Memo

0.00

Packaging

IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

Picklist Print

Page 1

Monday, August 28, 2017 12:58:29 PM

Work Order ID: 165746

165746

Parent Item: 649.4812

649 4812

Parent Item Name: Shim

Start Date: 9/12/2017

Required Date: 10/3/2017

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 12.11.01 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased				110	sf	127.6800	0.389	2.456842			
									**			17/09/22	DAS 40 9-89
M2024T3S 050													
2024-T3 .050 sheet													

Location

Loc Qty

Loc Code

MAT022

127.68

m134581

6.09

m137626

95.4

m137762

26.19

25



05848

SHEET 1 OF 1

DWG NO. 646.4800

REV: C

PREPARED BY M. SLY

DATE: 08/23/17

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: SHEETMETAL

APPROVED BY: ENGR. 

MFG

QC Dural Vowel

EFF.	CURRENT ORDER
------	---------------

TRANSACTION CODES (TC):

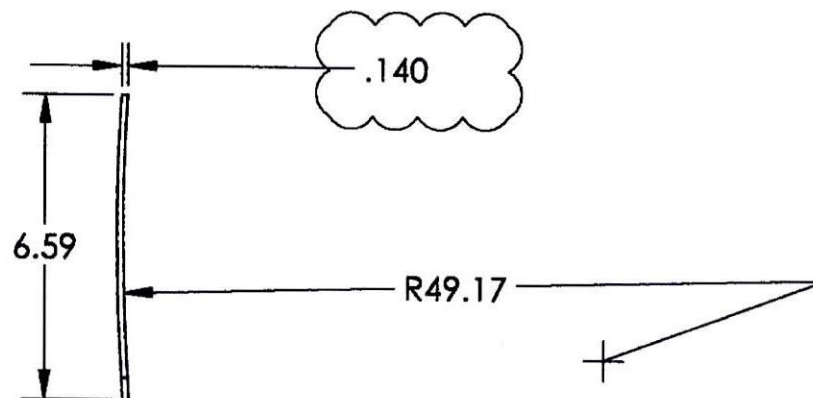
A-ADD	C-CREATE
R-REVISE	D-DELETE

REASON: ADD SHIMS AND REVISED DOUBLER THICKNESS

ECR:

ACTION ITEM:

SHEET 5, ZONE B5 IS:



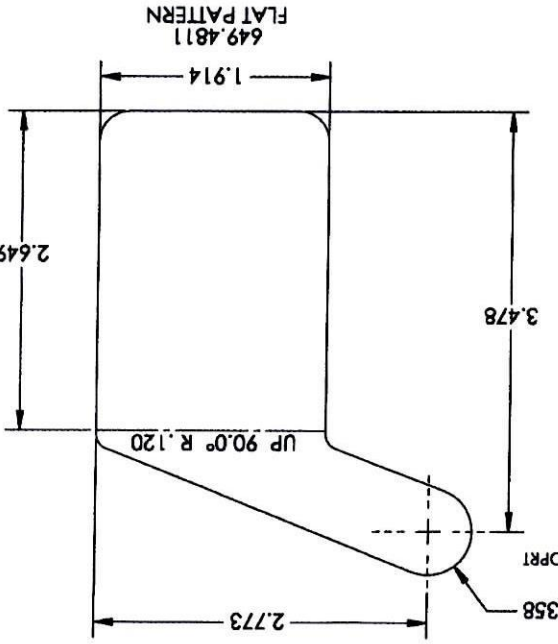
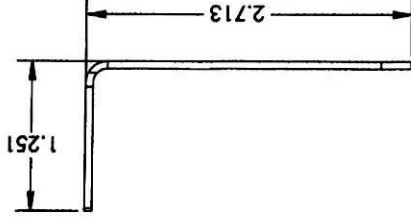
SHEET 1, BOM, IS:

10	C	649.4819		SHIM	1	2
9	C	649.4818		SHIM	1	2
F/N	TC	PART NUMBER	QTY	SHEETMETAL DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:				CHANGE CATEGORY	DER REVIEW REQUIRED	
☐ PATTERN ☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☒ BOM				☐ MAJOR ☒ MINOR	☐ YES ☒ NO	

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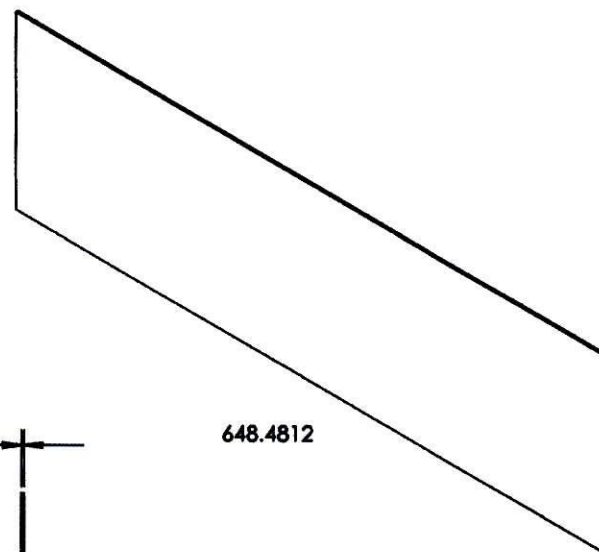
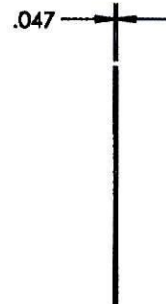
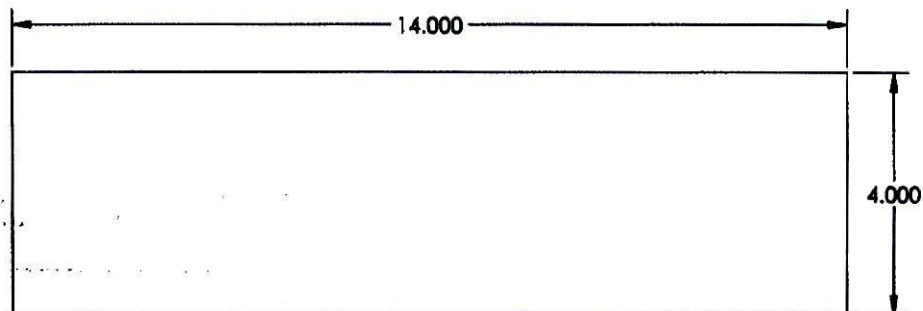
- OLIED**



REV.	DESCRIPTION	DATE	APPROV.
C	INCORPORATED ECH 08452	07-26-12	P. BRAYO
B	INCORPORATED ECH 08452	07-26-12	P. BRAYO
A	INCORPORATED ECH 08452	06-11-12	P. BRAYO
M/C	NETAL RELEASE	11-03-11	P. BRAYO
	LAST MODIFIED REVISION: 727		

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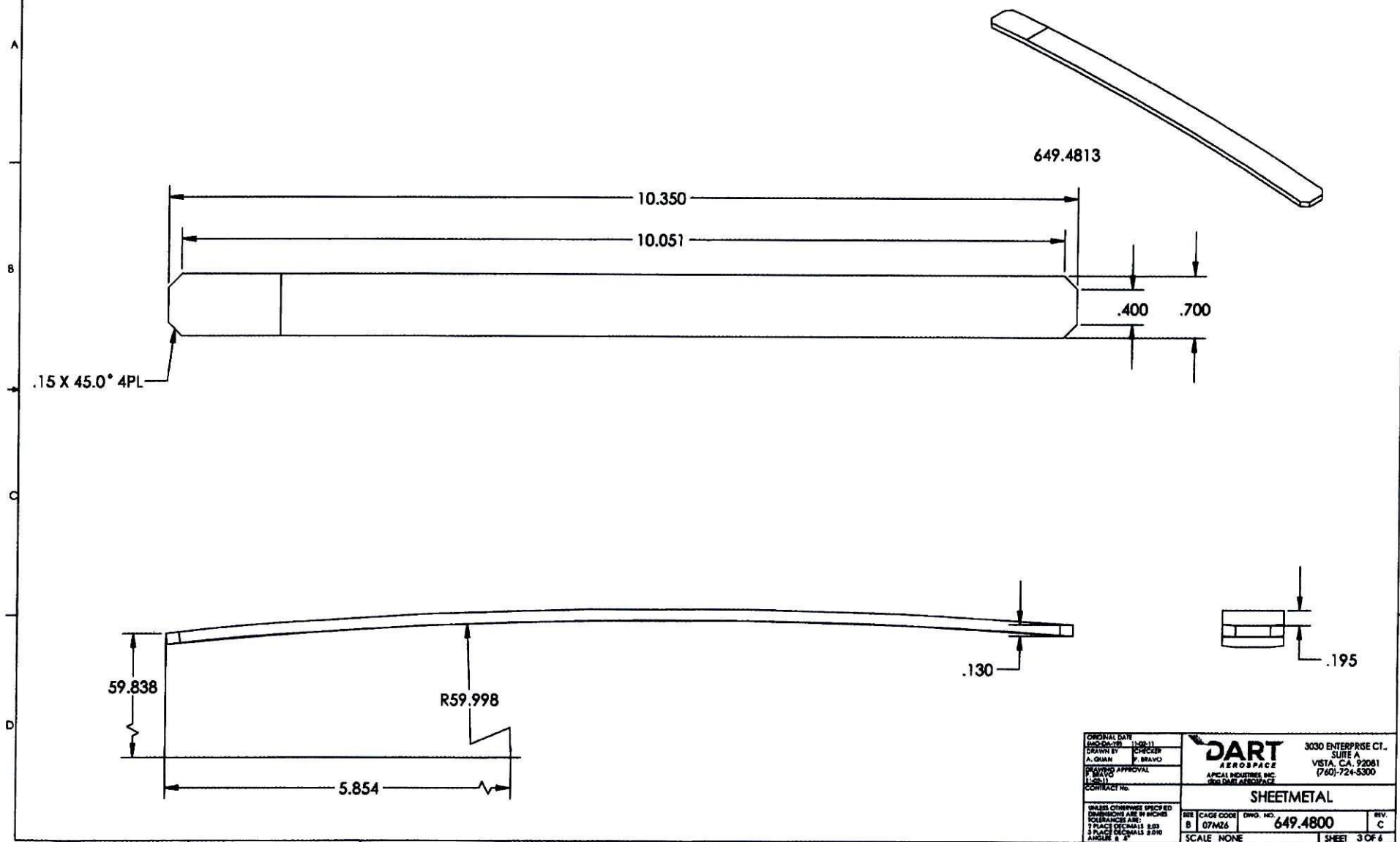
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ORIGINAL DATE 11-08-11		3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300	
DRAWN BY A. GUNN		DART AEROSPACE APICAL INDUSTRIES, INC. DBA DART AEROSPACE	
DESIGNED APPROVAL 11-08-11		SHEETMETAL	
CONTRACT NO.		SCALE NONE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.003 2 PLACE DECIMALS ±.005 ANGLES ±.2°		SHEET B 07M26	REV. C
DWG. NO. 649.4800		SHEET 2 OF 6	

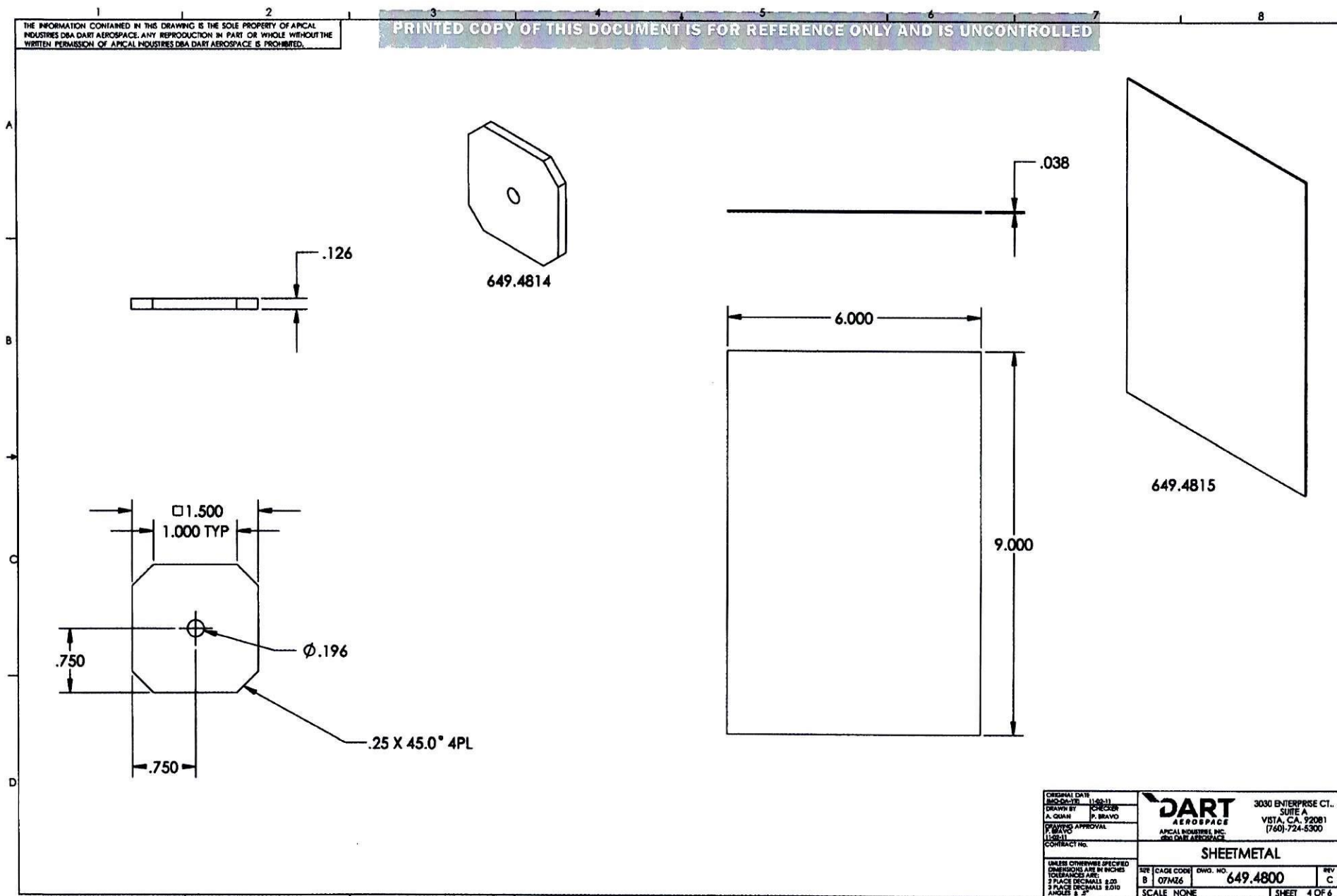
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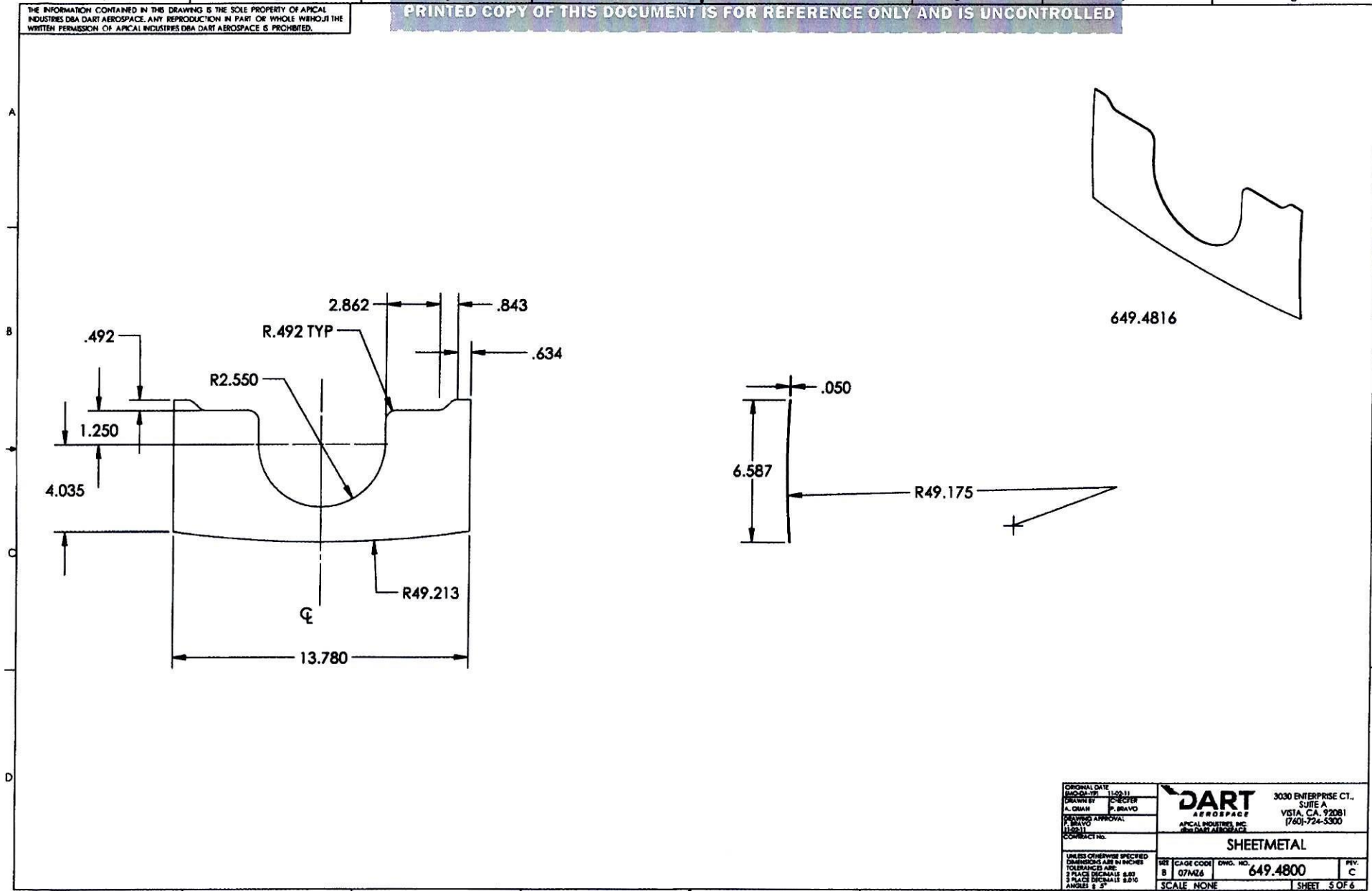
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ORIGINAL DATE 8/20/2011		3030 ENTERPRISE CT., SUITE A VISTA, CA, 92081 (760)-724-5300	
DRAWN BY A. GIBBY	CHECKED P. BRAYO	DART AEROSPACE APICAL INDUSTRIES, INC. DBA DART AEROSPACE	
DRAWING APPROVAL P. BRAYO (11/01/11)			
CONTRACT NO.		SHEETMETAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.01 2 PLACE DECIMALS ±.010 ANGLES ±.2°		SITE CAGE CODE DWO. NO. B 07M26 649.4800	REV C
SCALE NONE		SHEET 4 OF 6	

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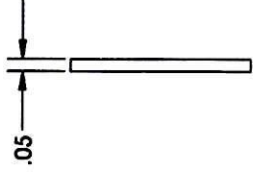
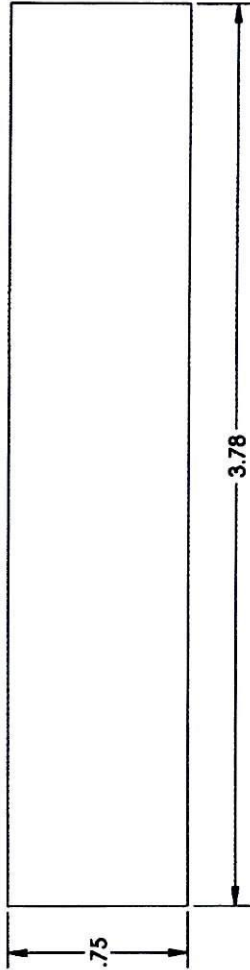
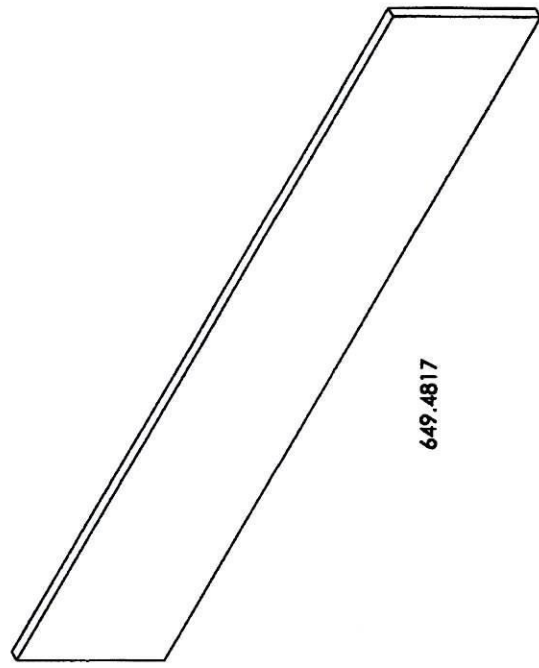
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ORIGINAL DATE 11/02/11		3030 ENTERPRISE CT., SUITE A	
DRAWN BY A. GUAN		VISTA, CA. 92081	
CHECKED BY P. BRAVO		(760) 724-5300	
DRAWING APPROVAL P. BRAVO		APICAL INDUSTRIES INC. DBA DART AEROSPACE	
CONTRACT NO.		SHEETMETAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.01 2 PLACE DECIMALS ±.05 ANGLES ±.5°		REV 8	REV. C
SCALE NONE		SHEET 5 OF 6	

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ORIGINAL DATE	10/11	3000 ENTERPRISE CT.
REVISION	1	SUITE A
APPROVED BY	APCAL	VISTA, CA 92081
DATE	07/02/06	1760-724-3300
CONTRACT NO.		
SHEETMETAL		
REV	07/02/06	649.4800
SCALE	NONE	SHEET 6 OF 6



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO038172**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO038172
PO Date: 10/27/17
Due Date: 10/27/17
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items												
Line Item	Job	Part	Rev	Description	Item Tax	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	165947	RBEM632V4002101-13	-	Gauge Handle Ø4mm -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2 WATER SEAL -Certificate of Conformity is required		Firmed	10/27/17	2 pcs	0 pcs	2 pcs	\$16.25/pcs	\$32.50
2	165697	649.4815	-	Shim ISSUE P/O: HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)		Firmed	10/26/17	6 pcs	0 pcs	6 pcs	\$22.15/pcs	\$132.90
3	165746	649.4812	-	Shim ISSUE P/O: HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2) PRIME IAW MIL-P-23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 2)		Firmed	10/27/17	6 pcs	0 pcs	6 pcs	\$22.15/pcs	\$132.90
4	165693	649.4813	-	Shim ISSUE P/O: As Per MPP-172 Section 2.1, Hard Anodize IAW MIL-A-8625, Type III, Class 2, Color Black As Per MPP-172 Section 4.2 Prime IAW MIL-P-23377J Type1 Class N		Firmed	10/27/17	10 pcs	0 pcs	10 pcs	\$16.25/pcs	\$162.50
5	166156	647.0410	-			Firmed	10/27/17	10 pcs	0 pcs	10 pcs	\$18.65/pcs	\$186.50



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914027

Date: 18-Oct-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
6 ea	Part: 649.4815 Shim Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils). Job: 21763	Rev: C PO: PO37888 Line: 1	
6 ea	Part: 649.4812 Shim Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils). Job: 21764	Rev: C PO: PO37888 Line: 2	SPR 10-30
10 ea	Part: 649.4813 Shim Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils). Job: 21765	Rev: C PO: PO37888 Line: 3	
10 ea	Part: 647.0410 Tube Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils). Job: 21766	Rev: N/C PO: PO37888 Line: 4	
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: 18/10/17			
Made in Canada.			



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914027

Date: 18-Oct-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

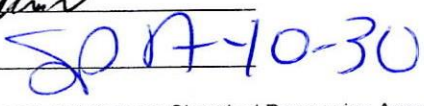
Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via
		OUR TRUCK
Quantity	Description	
	Certified Signature: 	
	Receiver Signature: 	
	A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited.	
	Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.	
	Made in Canada.	